

Date: Tuesday, 1/3/2006 4:20:34 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: AFT CAP		
Job Number	: 25381					
Estimate Number	: 10312					
P.O. Number	: N/A		Part Number	: D2646		
This Issue	: 1/3/2006	S.O. No. : N/A	Drawing Number	: D2646 REV B		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: B		
Previous Run	: 23370		Material	: N/A		
Written By	<u>See COMMENT Below</u>		Due Date	: 1/28/2006		
Checked & Approved By	<u>See ABOVE USER &amp; DATE</u>		Qty:	50	Um:	Each
Comment	: Est: G 05.08.22 Hole size revised in Step 5 KJ/JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PG	PURCHASING	
		Comment: PURCHASING Issue P/O: <u>00000341</u> <i>Placeholder</i> 1-Spin as per Dwg D2646 2-Material release note required	
2.0	D2646	Aft Cap	
		Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s) AFT CAP	
3.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Receive & Inspect for Transit Damage Ensure Material Release Note is attached	 <i>C:\Local\01\118</i> <i>(50)</i>
4.0	QC6	DIMENSIONAL CHECK	 <i>06-01-15 50</i>
		Comment: DIMENSIONAL CHECK Inspect dimensions as per Dwg D2646	 <i>06-01-15 50</i>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Drill using DT8026 as per Dwg D2646. 2-Open holes to 0.391" and c'sink as per Dwg D2646. 3-Deburr <u>0.250"</u>	 <i>SP 06/01/23 (50)</i>
			<i>SP 06-01-20</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/05/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/3/2006 4:20:35 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CAP

Job Number: 25381

Part Number: D2646

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

DL 06/01/28

(50)

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-02-22

(50)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL 06/04/28

(50)

9.0 NAS1330C3KB116

Insert



Comment: Qty.: 2.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

2

NAS1330C3KB116 ✓

Insert

89XM19014  
11XM19349

DL 06/04/28 (50)

10.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install inserts as per Dwg D2646

DL 06/04/28 (50)

11.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP 4

DL 06/05/02 (50)

13.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/05/02 (50)

IN 06-05-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

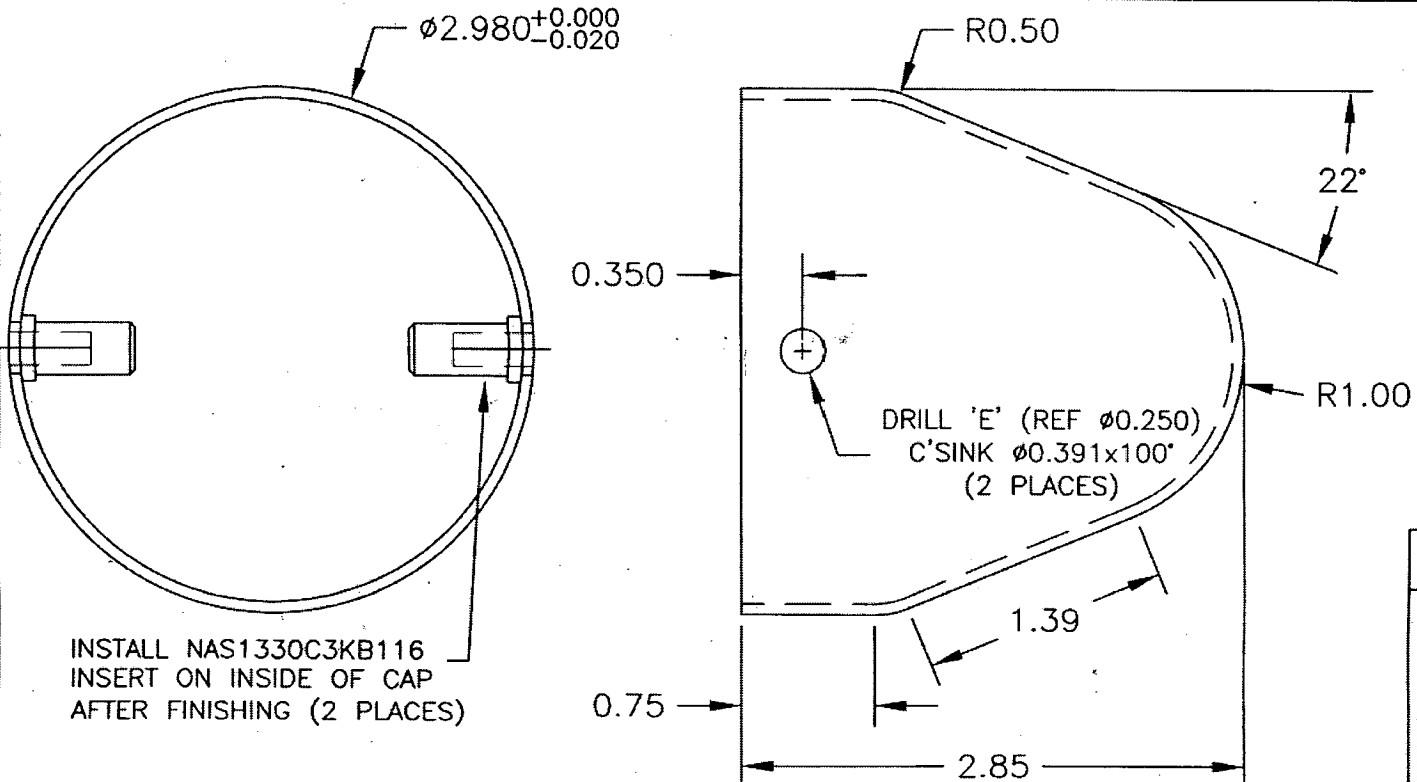
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN DS	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	REV. B
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2646	SHEET 1 OF 1
DATE 05.04.01		TITLE AFT CAP	SCALE 1:1

**D2646 AFT CAP**

- 1) MATERIAL: 1100-0 0.063 THICK (QQ-A-250/1)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**RELEASED**  
05.08.09 *[Signature]*

WORK CARD  
NO. 25381

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sm

Sieg's Manufacturing ltd.

604 530-7455 fax 604 530-7490  
6236-205 Street, Langley, British Columbia, Canada. V2Y 1N7

## **INSPECTION REPORT**

DATE: Jan. 5, 2006

CUSTOMER: Dart Aerospace

PS  
INVOICE #: 29775 SUPPLIER #: N/A

DESCRIPTION OF INSPECTION: D264b Rev B Aft Cap.

NOTES OF INSPECTION: good.

**NOTES OF REJECT:**





**Alcoa Mill Products**  
1480 Manheim Pike  
Lancaster Pa 17601

# Certification of Test Results

0513Y5-7  
PO CA7197

SOLD TO

COPPER & BRASS SALES INC  
22355 WEST ELEVEN MILE ROAD  
SOUTHFIELD, MI 48034

SHIP TO

COPPER & BRASS  
8307 TRIAD DR  
GREENSBORO, NC 27410

CERT NO 0000615298  
DATE 12/21/2004  
SKID NO 336756  
SKID WGT 10,029  
PAGE 1 OF 1

ORDER NO	LB6427	PO NO	CA7197				
ITEM NO	1	PART NO	050393-8				
ALLOY	1100	TEMPER	O	FORM	COIL		
GAUGE	.06300	WIDTH	48.0000	LENGTH	0.0000		

MILL FINISH  
NON ANODIZE QUALITY  
OUT: STANDARD MILL FINISH  
IN: STANDARD MILL FINISH  
NOT EMBOSSED

LOT: 242284 COIL: B01 DROP: 449326

INGOT	SI	FE	CU	MN	MG	CR	NI	ZN	TI
4493262	0.09	0.41	0.08	0.02	0.008	0.002	0.009	0.006	0.02

HEAD ULTIMATE STRENGTH 12.8 KSI  
TAIL ULTIMATE STRENGTH 13.1 KSI  
HEAD YIELD STRENGTH (OFFSET = .2%) 5.3 KSI  
TAIL YIELD STRENGTH (OFFSET = .2%) 5.7 KSI  
HEAD ELONGATION (G.L. = 2 IN) 35.5 %  
TAIL ELONGATION (G.L. = 2 IN) 34 %

CHEMICAL COMPOSITION ACCORDING TO ASTM E-1251-04  
MECHANICAL PROPERTIES ACCORDING TO ASTM B-557-02a

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF:  
ASME SB209 1100 O, AMS 4001H 1100 O,  
ASTM B209-04 1100 O, AMS-QQ-A-250/1 1100 O

CERTIFICATION OF TEST RESULTS SHALL NOT BE REPRODUCED EXCEPT IN FULL  
\*\* END OF CERTIFICATION \*\*